



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-1

Job Sheet 201656



Part No: D3278-1

Job Qty: 80 pcs

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/8/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/10/19

Description:

Type: SOLD

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 rev.c dwg EC verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	80 pcs		12/10/19	0.00	2.31	Bandsaw - 1		BM 19-10-23
102	Outsource - 5 - Machining	80 pcs		12/10/19			MEM001-VC		PL 11/11/2019
104	Packaging 2-1 - Receive - B4B	80 pcs		12/10/19	0.00	0.00	Packaging 2 - 1-B4B		NOV 11 2019
106	QC 6	80 pcs		12/10/19	0.00	0.00	QC 6 - 16		81 NOV 13 2019
110	HAAS 5 Axis - B4B	80 pcs		12/10/19	0.06	25.09	HAAS - 5 - B4B		
135	QC 8	80 pcs		12/10/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		

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140	Handfinish - 1-1 Chemical-B4B	80 pcs	12/10/19	0.00	0.76	QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	NOV 14 2019
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)-B4B	80 pcs	12/10/19	0.00	0.60	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
160	QC 3	80 pcs	12/10/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	

						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	DAS
						QC 3 - 40	NOV 20 2019 40
						QC 3 - 19	9-89
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	80	12/10/19	0.00	0.00	Packaging 3 - 1 - B4B	
	pcs					Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	DAS
						Packaging 3 - 4 - B4B	74
						Packaging 3 - 5 - B4B	9-89
						Packaging 3 - 6 - B4B	NOV 20 2019
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	

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					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	80 pcs	12/10/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	5-53

Part Op 100 - (Bandsaw) Cut blank: 2.00" x 1.00" x 2.550" long
 Descriptions: 102 - (Outsource process - Machining)
 104 - (Receive & Inspect for Damage & Mat'l Certs)
 106 - (QC6- All purchased or subcontracted products)
 110 - (HAAS CNC vertical machine #5) 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
 180 - (QC21- Final Inspection - Work Order Release)

NOV 21 2019

1016044863 x80 Plus 23oct2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	17.3600 ft (.217 ea)	100-Bandsaw - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.000X02.000	17	62	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches	+ 0.005 - 0.000	0.103 0.098	
2	Support	0.359inches	± 0.005	0.364 0.354	
3	Support	0.609inches	± 0.010	0.619 0.599	
4	Support	0.250inches	± 0.010	0.260 0.240	
5	Support	1.480inches	± 0.005	1.485 1.475	
6	Support	0.125inches	± 0.010	0.135 0.115	
7	Support	0.119inches	+ 0.005 - 0.004	0.124 0.115	
8	Support	2.439inches	± 0.010	2.449 2.429	
9	Support	1.980inches	± 0.010	1.990 1.970	
10	Support	0.130inches	± 0.030	0.160 0.100	
11	Support	0.257inches	+ 0.005 - 0.000	0.262 0.257	
12	Support	0.375inches	± 0.010	0.385 0.365	
13	Support	0.875inches	± 0.010	0.885 0.865	
14	Support	0.500inches	± 0.010	0.510 0.490	
15	Support	0.400inches	± 0.010	0.410 0.390	
16	Support	1.000inches	± 0.030	1.030 0.970	
17	Support	1.720inches	± 0.010	1.730 1.710	
18	Support	0.125inches	± 0.010	0.135 0.115	
19	Support	0.125inches	± 0.010	0.135 0.115	

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							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1-813-632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S225481



Part: D3278-1

Job No: 201656

Serial No/Batch: S225481

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/23/19

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

https://www.plexonline.com/ac9fd06f-2352-4e75-a8a1-434e7edbf0/Plexus_Control/Report_Viewr_2.asp?URL=/Part/Ink_Sheet.asp?URL=/Part/Ink_Sheet.asp

170	Packaging 3-1 - Stock - B4B	80 pcs	12/10/19	0.00	0.00	QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	

10/8/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

180 QC 21 - SA	80 pcs	12/10/19	0.00 0.00	Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

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150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____
 _____ FINISH TIME: _____
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
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Job Allocations

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19	Support	0.125inches ± 0.010	0.135 0.115		

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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

NCR No. _____

DEPARTMENT/PROCESS

DISPOSITION

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Skid-tube ☐
Machining ☐
Large Fab ☐

Rework ☐
Scrap ☐
Use-as-is ☐

Job: _____

Part No. _____

MRB (QS1042)

QTY Affected: _____

Sequence #: _____

Disposition

Description Work Order Deviation

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

FAULT CATEGORY

Positioned Wrong	☐
Outside Tolerance	☐
Drawing	☐
Finish	☐
Part Lost/Missing	☐
Misread	☐
Power Loss/Surge	☐
Folio/Program	☐
Grain Direction	☐
Weld	☐
Wrong Stock Pulled	☐
Out of Sequence	☐
Off-set/Set-up	☐

Contamination	☐
Misaligned/off center	☐
BOM/Route	☐
Broken/Damage/Defect	☐
Incomplete/Unclear Instructions	☐
Drill Holes	☐
Fit/Function	☐

Pressure/Forced	☐
Bending	☐
Crushing	☐
Cracks	☐
Crimp/Kink/Ripple/Wave/Twist	☐
Marks/Chatter	☐
Mislabeled	☐

Other/Details: _____

Root Cause

Operator	☐
Manufacturing Process	☐
Equip/Tooling	☐
Handling/Preservation	☐
Material	☐
Product Improvement	☐
Process Improvement	☐
Human Factors	☐



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044863



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankeek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044863

PO Date: 10/23/19

Due Date: 10/30/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201656	D3278-1	D3278 REV.C	DAS 81 9-89		Support : Various STC's (Outsource process - Machining)	Firmed	-	10/30/19	80 pcs	0 pcs	80 pcs	\$46.94/pcs	\$3,755.20
NO PAINT, NO ALODINE, PLEASE SUPPLY ASAP														
2	201657	D3278-2	D3278 REV.C			Support : Various STC's	Firmed	-	10/30/19	80 pcs	0 pcs	80 pcs	\$46.94/pcs	\$3,755.20
NO PAINT, NO ALODINE, PLEASE SUPPLY ASAP														
													Grand Total:	\$7,510.40

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 10/23/19 12:53 PM dart.lussier.patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 26114
Shipment Date: 08-Nov-2019
Ship Via: Pick up at METEC
Order Number: 4332
Order Date: 10/24/2019

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB044863
Terms: Net 60 Days

Quantity						Description	Revision	Job Number
Item	Open	Shipped	B/O	Cancelled	Unit			
1	80	80	0	0	EA	DART-D3278-1P Support, unpainted material supplied by DART	C	4332-01
2	80	80	0	0	EA	DART-D3278-2P Support, unpainted material supplied by DART	C	4332-02

RECEIVED

NOV 08 2019

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Matthew N. Nilon

Packing Clerk's Signature
Metec Metal Technology Inc

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

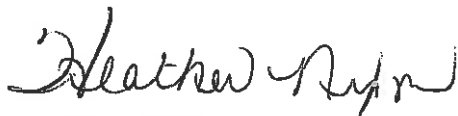
same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
80	D3278-1P	Support	C	S225434	Unpainted	HB044863
80	D3278-2P	Support	C	S225481	Unpainted	HB044863

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Heather Nixon

Vankleek Hill, November 8, 2019